

CLAIMS

Claims:

What is claimed is:

1. A copolymer comprising an isoolefin and a multiolefin, the copolymer having a copolymer sequence distribution defined by:

$$F = m A / (1 + mA)^2$$

wherein m is the copolymer sequence distribution parameter; A is the molar ratio of multiolefin to isoolefin in the copolymer; and F is the isoolefin-multiolefin-multiolefin triad fraction in the copolymer; wherein m is from greater than 1.5.

2. The copolymer of claim 1, wherein m is from greater than 2.0.
3. The copolymer of claim 1, wherein m is from greater than 2.5.
4. The copolymer of claim 1, wherein m is from greater than 3.5.
5. The copolymer of any of the preceding claims, wherein the multiolefin is a conjugated diene, preferably isoprene.
6. The copolymer of any of the preceding claims, wherein the multiolefin content is from greater than 0.5 mol%.
7. The copolymer of any of the preceding claims, wherein the multiolefin content is from greater than 1.0 mol%.

8. The copolymer of any of the preceding claims, wherein the multiolefin content is from greater than 2.5 mol%.
9. The copolymer of any of the preceding claims, wherein the multiolefin content is from greater than 5.0 mol%.
10. A copolymer comprising isobutylene and isoprene, the copolymer having a copolymer sequence distribution defined by:

$$F = m A / (1 + mA)^2$$

wherein m is the copolymer sequence distribution parameter; A is the molar ratio of isoprene to isobutylene in the copolymer; and F is the isobutylene-isoprene-isoprene triad fraction in the copolymer; wherein m is from greater than 1.5.

11. The copolymer of claim 10, wherein m is from greater than 2.0.
12. The copolymer of claim 10, wherein m is from greater than 2.5.
13. The copolymer of claim 10, wherein m is from greater than 3.5.
14. The copolymer of any of claims 10-13, wherein the isoprene content is from greater than 0.5 mol%.
15. The copolymer of any of claims 10-13, wherein the isoprene content is from greater than 1.0 mol%.
16. The copolymer of any of claims 10-13, wherein the isoprene content is from greater than 2.5 mol%.

17. The copolymer of any of claims 10-13, wherein the isoprene content is from greater than 5.0 mol%.
18. A copolymer comprising an isoolefin and a multiolefin, the copolymer having a copolymer sequence distribution defined by:

$$F = m A / (1 + mA)^2$$

wherein m is the copolymer sequence distribution parameter; A is the molar ratio of multiolefin to isoolefin in the copolymer; and F is the isoolefin-multiolefin-multiolefin triad fraction in the copolymer; wherein m is from 1.10 to 1.25.

19. The copolymer of claim 18, wherein m is from 1.15 to 1.20.
20. The copolymer of claim 18, wherein m is from 1.15 to 1.25.
21. The copolymer of claim 18, wherein m is about 1.20.
22. The copolymer of any of claims 18-21, wherein the multiolefin is a conjugated diene, preferably isoprene.
23. The copolymer of any of claims 18-22, wherein the multiolefin content is from greater than 0.5 mol%.
24. The copolymer of any of claims 18-22, wherein the multiolefin content is from greater than 1.0 mol%.
25. The copolymer of any of claims 18-22, wherein the multiolefin content is from greater than 2.5 mol%.

26. The copolymer of any of claims 18-22, wherein the multiolefin content is from greater than 5.0 mol%.
27. A copolymer comprising isobutylene and isoprene, the copolymer having a copolymer sequence distribution defined by:

$$F = m A / (1 + mA)^2$$

wherein m is the copolymer sequence distribution parameter; A is the molar ratio of isoprene to isobutylene in the copolymer; and F is the isobutylene-isoprene-isoprene triad fraction in the copolymer; wherein m is from 1.10 to 1.25.

28. The copolymer of claim 18, wherein m is from 1.15 to 1.20.
29. The copolymer of claim 18, wherein m is from 1.15 to 1.25.
30. The copolymer of claim 18, wherein m is about 1.20.
31. The copolymer of any of claims 27-30, wherein the isoprene content is from greater than 0.5 mol%.
32. The copolymer of any of claims 27-30, wherein the isoprene content is from greater than 1.0 mol%.
33. The copolymer of any of claims 27-30, wherein the isoprene content is from greater than 2.5 mol%.
34. The copolymer of any of claims 27-30, wherein the isoprene content is from greater than 5.0 mol%.

35. A copolymer produced by the process comprising contacting an isoolefin, preferably isobutylene, a multiolefin, one or more Lewis acid(s), one or more initiator(s), and a diluent comprising one or more hydrofluorocarbon(s) (HFC's); the copolymer having a copolymer sequence distribution defined by:

$$F = m A / (1 + mA)^2$$

wherein m is the copolymer sequence distribution parameter; A is the molar ratio of multiolefin to isoolefin in the copolymer; and F is the isoolefin-multiolefin-multiolefin triad fraction in the copolymer; wherein m is from greater than 1.5 or m is from 1.10 to 1.25.

36. The copolymer of claim 10, wherein m is from greater than 2.0.
37. The copolymer of claim 10, wherein m is from greater than 2.5.
38. The copolymer of claim 10, wherein m is from greater than 3.5.
39. The copolymer of claim 18, wherein m is from 1.15 to 1.20.
40. The copolymer of claim 18, wherein m is from 1.15 to 1.25.
41. The copolymer of claim 18, wherein m is about 1.20.
42. The copolymer of claim 35, wherein the multiolefin is a conjugated diene, preferably isoprene.
43. The copolymer of any of claims 35-42, wherein the multiolefin content is from greater than 0.5 mol%.

44. The copolymer of any of claims 35-42, wherein the multiolefin content is from greater than 1.0 mol%.
45. The copolymer of any of claims 35-42, wherein the multiolefin content is from greater than 2.5 mol%.
46. The copolymer of any of claims 35-42, wherein the multiolefin content is from greater than 5.0 mol%.
47. The copolymer of any of claims 35-46, wherein one or more hydrofluorocarbon(s) is represented by the formula: $C_xH_yF_z$ wherein x is an integer from 1 to 40 and y and z are integers of one or more.
48. The copolymer of claim 47, wherein x is from 1 to 10.
49. The copolymer of claim 47, wherein x is from 1 to 6.
50. The copolymer of claim 47, wherein x is from 1 to 3.
51. The copolymer of claim 35, wherein the one or more hydrofluorocarbon(s) is independently selected from the group consisting of fluoromethane; difluoromethane; trifluoromethane; fluoroethane; 1,1-difluoroethane; 1,2-difluoroethane; 1,1,1-trifluoroethane; 1,1,2-trifluoroethane; 1,1,1,2-tetrafluoroethane; 1,1,2,2-tetrafluoroethane; 1,1,1,2,2-pentafluoroethane; 1-fluoropropane; 2-fluoropropane; 1,1-difluoropropane; 1,2-difluoropropane; 1,3-difluoropropane; 2,2-difluoropropane; 1,1,1-trifluoropropane; 1,1,2-trifluoropropane; 1,1,3-trifluoropropane; 1,2,2-trifluoropropane; 1,2,3-trifluoropropane; 1,1,1,2-tetrafluoropropane; 1,1,1,3-tetrafluoropropane; 1,1,2,2-tetrafluoropropane; 1,1,2,3-tetrafluoropropane; 1,1,3,3-tetrafluoropropane; 1,2,2,3-tetrafluoropropane; 1,1,1,2,2-pentafluoropropane; 1,1,1,2,3-pentafluoropropane; 1,1,1,3,3-pentafluoropropane; 1,1,2,2,3-pentafluoropropane; 1,1,2,3,3-

pentafluoropropane; 1,1,1,2,2,3-hexafluoropropane; 1,1,1,2,3,3-hexafluoropropane; 1,1,1,3,3,3-hexafluoropropane; 1,1,1,2,2,3,3-heptafluoropropane; 1,1,1,2,3,3,3-heptafluoropropane; 1-fluorobutane; 2-fluorobutane; 1,1-difluorobutane; 1,2-difluorobutane; 1,3-difluorobutane; 1,4-difluorobutane; 2,2-difluorobutane; 2,3-difluorobutane; 1,1,1-trifluorobutane; 1,1,2-trifluorobutane; 1,1,3-trifluorobutane; 1,1,4-trifluorobutane; 1,2,2-trifluorobutane; 1,2,3-trifluorobutane; 1,3,3-trifluorobutane; 2,2,3-trifluorobutane; 1,1,1,2-tetrafluorobutane; 1,1,1,3-tetrafluorobutane; 1,1,1,4-tetrafluorobutane; 1,1,2,2-tetrafluorobutane; 1,1,2,3-tetrafluorobutane; 1,1,2,4-tetrafluorobutane; 1,1,3,3-tetrafluorobutane; 1,1,3,4-tetrafluorobutane; 1,1,4,4-tetrafluorobutane; 1,2,2,3-tetrafluorobutane; 1,2,2,4-tetrafluorobutane; 1,2,3,3-tetrafluorobutane; 1,2,3,4-tetrafluorobutane; 2,2,3,3-tetrafluorobutane; 1,1,1,2,2-pentafluorobutane; 1,1,1,2,3-pentafluorobutane; 1,1,1,2,4-pentafluorobutane; 1,1,1,3,3-pentafluorobutane; 1,1,1,3,4-pentafluorobutane; 1,1,1,4,4-pentafluorobutane; 1,1,2,2,3-pentafluorobutane; 1,1,2,2,4-pentafluorobutane; 1,1,2,3,3-pentafluorobutane; 1,1,2,4,4-pentafluorobutane; 1,1,3,3,4-pentafluorobutane; 1,2,2,3,3-pentafluorobutane; 1,2,2,3,4-pentafluorobutane; 1,1,1,2,2,3-hexafluorobutane; 1,1,1,2,2,4-hexafluorobutane; 1,1,1,2,3,3-hexafluorobutane; 1,1,1,2,3,4-hexafluorobutane; 1,1,1,2,4,4-hexafluorobutane; 1,1,1,3,3,4-hexafluorobutane; 1,1,1,3,4,4-hexafluorobutane; 1,1,1,4,4,4-hexafluorobutane; 1,1,2,2,3,3-hexafluorobutane; 1,1,2,2,3,4-hexafluorobutane; 1,1,2,2,4,4-hexafluorobutane; 1,1,2,3,3,4-hexafluorobutane; 1,1,2,3,4,4-hexafluorobutane; 1,2,2,3,3,4-hexafluorobutane; 1,1,1,2,2,3,3-heptafluorobutane; 1,1,1,2,2,4,4-heptafluorobutane; 1,1,1,2,3,3,4-heptafluorobutane; 1,1,1,2,3,4,4-heptafluorobutane; 1,1,1,2,4,4,4-heptafluorobutane; 1,1,1,3,3,4,4-heptafluorobutane; 1,1,1,2,2,3,3,4-octafluorobutane; 1,1,1,2,2,3,4,4-octafluorobutane; 1,1,1,2,3,3,4,4-octafluorobutane; 1,1,1,2,2,4,4,4-octafluorobutane; 1,1,1,2,3,4,4,4-octafluorobutane;

octafluorobutane; 1,1,1,2,2,3,3,4,4-nonafluorobutane; 1,1,1,2,2,3,4,4,4-nonafluorobutane; 1-fluoro-2-methylpropane; 1,1-difluoro-2-methylpropane; 1,3-difluoro-2-methylpropane; 1,1,1-trifluoro-2-methylpropane; 1,1,3-trifluoro-2-methylpropane; 1,3-difluoro-2-(fluoromethyl)propane; 1,1,1,3-tetrafluoro-2-methylpropane; 1,1,3,3-tetrafluoro-2-methylpropane; 1,1,3-trifluoro-2-(fluoromethyl)propane; 1,1,1,3,3-pentafluoro-2-methylpropane; 1,1,3,3-tetrafluoro-2-(fluoromethyl)propane; 1,1,1,3-tetrafluoro-2-(fluoromethyl)propane; fluorocyclobutane; 1,1-difluorocyclobutane; 1,2-difluorocyclobutane; 1,3-difluorocyclobutane; 1,1,2-trifluorocyclobutane; 1,1,3-trifluorocyclobutane; 1,2,3-trifluorocyclobutane; 1,1,2,2-tetrafluorocyclobutane; 1,1,3,3-tetrafluorocyclobutane; 1,1,2,2,3-pentafluorocyclobutane; 1,1,2,3,3-pentafluorocyclobutane; 1,1,2,2,3,3-hexafluorocyclobutane; 1,1,2,2,3,4-hexafluorocyclobutane; 1,1,2,3,3,4-hexafluorocyclobutane; 1,1,2,2,3,3,4-heptafluorocyclobutane; vinyl fluoride; 1,1-difluoroethene; 1,2-difluoroethene; 1,1,2-trifluoroethene; 1-fluoropropene, 1,1-difluoropropene; 1,2-difluoropropene; 1,3-difluoropropene; 2,3-difluoropropene; 3,3-difluoropropene; 1,1,2-trifluoropropene; 1,1,3-trifluoropropene; 1,2,3-trifluoropropene; 1,3,3-trifluoropropene; 2,3,3-trifluoropropene; 3,3,3-trifluoropropene; 1-fluoro-1-butene; 2-fluoro-1-butene; 3-fluoro-1-butene; 4-fluoro-1-butene; 1,1-difluoro-1-butene; 1,2-difluoro-1-butene; 1,3-difluoropropene; 1,4-difluoro-1-butene; 2,3-difluoro-1-butene; 2,4-difluoro-1-butene; 3,3-difluoro-1-butene; 3,4-difluoro-1-butene; 4,4-difluoro-1-butene; 1,1,2-trifluoro-1-butene; 1,1,3-trifluoro-1-butene; 1,1,4-trifluoro-1-butene; 1,2,3-trifluoro-1-butene; 1,2,4-trifluoro-1-butene; 1,3,3-trifluoro-1-butene; 1,3,4-trifluoro-1-butene; 1,4,4-trifluoro-1-butene; 2,3,3-trifluoro-1-butene; 2,3,4-trifluoro-1-butene; 2,4,4-trifluoro-1-butene; 3,3,4-trifluoro-1-butene; 3,4,4-trifluoro-1-butene; 4,4,4-trifluoro-1-butene; 1,1,2,3-tetrafluoro-1-butene; 1,1,2,4-tetrafluoro-1-butene; 1,1,3,3-tetrafluoro-1-butene; 1,1,3,4-tetrafluoro-1-butene; 1,1,4,4-tetrafluoro-1-butene; 1,2,3,3-tetrafluoro-1-butene; 1,2,3,4-tetrafluoro-1-butene; 1,2,4,4-tetrafluoro-1-butene; 1,3,3,4-

tetrafluoro-1-butene; 1,3,4,4-tetrafluoro-1-butene; 1,4,4,4-tetrafluoro-1-butene; 2,3,3,4-tetrafluoro-1-butene; 2,3,4,4-tetrafluoro-1-butene; 2,4,4,4-tetrafluoro-1-butene; 3,3,4,4-tetrafluoro-1-butene; 3,4,4,4-tetrafluoro-1-butene; 1,1,2,3,3-pentafluoro-1-butene; 1,1,2,3,4-pentafluoro-1-butene; 1,1,2,4,4-pentafluoro-1-butene; 1,1,3,3,4-pentafluoro-1-butene; 1,1,3,4,4-pentafluoro-1-butene; 1,1,4,4,4-pentafluoro-1-butene; 1,2,3,3,4-pentafluoro-1-butene; 1,2,3,4,4-pentafluoro-1-butene; 1,2,4,4,4-pentafluoro-1-butene; 2,3,3,4,4-pentafluoro-1-butene; 2,3,4,4,4-pentafluoro-1-butene; 3,3,4,4,4-pentafluoro-1-butene; 1,1,2,3,3,4-hexafluoro-1-butene; 1,1,2,3,4,4-hexafluoro-1-butene; 1,1,2,4,4,4-hexafluoro-1-butene; 1,2,3,3,4,4-hexafluoro-1-butene; 1,2,3,4,4,4-hexafluoro-1-butene; 2,3,3,4,4,4-hexafluoro-1-butene; 1,1,2,3,3,4,4-heptafluoro-1-butene; 1,1,2,3,4,4,4-heptafluoro-1-butene; 1,1,3,3,4,4,4-heptafluoro-1-butene; 1,2,3,3,4,4,4-heptafluoro-1-butene; 1-fluoro-2-butene; 2-fluoro-2-butene; 1,1-difluoro-2-butene; 1,2-difluoro-2-butene; 1,3-difluoro-2-butene; 1,4-difluoro-2-butene; 2,3-difluoro-2-butene; 1,1,1-trifluoro-2-butene; 1,1,2-trifluoro-2-butene; 1,1,3-trifluoro-2-butene; 1,1,4-trifluoro-2-butene; 1,2,3-trifluoro-2-butene; 1,2,4-trifluoro-2-butene; 1,1,1,2-tetrafluoro-2-butene; 1,1,1,3-tetrafluoro-2-butene; 1,1,1,4-tetrafluoro-2-butene; 1,1,2,3-tetrafluoro-2-butene; 1,1,2,4-tetrafluoro-2-butene; 1,2,3,4-tetrafluoro-2-butene; 1,1,1,2,3-pentafluoro-2-butene; 1,1,1,2,4-pentafluoro-2-butene; 1,1,1,3,4-pentafluoro-2-butene; 1,1,1,4,4-pentafluoro-2-butene; 1,1,2,3,4-pentafluoro-2-butene; 1,1,2,4,4-pentafluoro-2-butene; 1,1,1,2,3,4-hexafluoro-2-butene; 1,1,1,2,4,4-hexafluoro-2-butene; 1,1,1,3,4,4-hexafluoro-2-butene; 1,1,1,4,4,4-hexafluoro-2-butene; 1,1,2,3,4,4-hexafluoro-2-butene; 1,1,1,2,3,4,4-heptafluoro-2-butene; 1,1,1,2,4,4,4-heptafluoro-2-butene; and mixtures thereof.

52. The copolymer of claim 35, wherein the one or more hydrofluorocarbon(s) is independently selected from the group consisting of fluoromethane,

difluoromethane, trifluoromethane, 1,1-difluoroethane, 1,1,1-trifluoroethane, 1,1,1,2-tetrafluoroethane, and mixtures thereof.

53. The copolymer of claim 35, wherein the diluent comprises from 15 to 100 volume % HFC based upon the total volume of the diluent.
54. The copolymer of claim 35, wherein the diluent comprises from 20 to 100 volume % HFC based upon the total volume of the diluent.
55. The copolymer of claim 35, wherein the diluent comprises from 25 to 100 volume % HFC based upon the total volume of the diluent.
56. The copolymer of claim 35, wherein the diluent further comprises a hydrocarbon, a non-reactive olefin, and/or an inert gas.
57. The copolymer of claim 56, wherein the hydrocarbon is a halogenated hydrocarbon other than an HFC.
58. The copolymer of claim 57, wherein the halogenated hydrocarbon is methyl chloride.
59. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula MX_4 ;
wherein M is a Group 4, 5, or 14 metal; and
each X is a halogen.
60. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula MR_nX_{4-n} ;
wherein M is Group 4, 5, or 14 metal;
each R is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;

n is an integer from 0 to 4; and
each X is a halogen.

61. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $M(RO)_nR'_mX_{4-(m+n)}$;
wherein M is Group 4, 5, or 14 metal;
each RO is a monovalent C_1 to C_{30} hydrocarboxy radical independently selected from the group consisting of an alkoxy, aryloxy, arylalkoxy, alkylaryloxy radicals;
each R' is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
 n is an integer from 0 to 4;
 m is an integer from 0 to 4, wherein the sum of n and m is not more than 4;
and
each X is a halogen.
62. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $M(RC=OO)_nR'_mX_{4-(m+n)}$;
wherein M is Group 4, 5, or 14 metal;
each $RC=OO$ is a monovalent C_2 to C_{30} hydrocarbacyl radical independently selected from the group consisting of an alkacyloxy, arylacyloxy, arylalkylacyloxy, alkylarylacyloxy radicals;
each R' is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
 n is an integer from 0 to 4;
 m is an integer from 0 to 4, wherein the sum of n and m is not more than 4;
and
each X is a halogen.

63. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula MOX_3 ;
wherein M is a Group 5 metal; and
each X is a halogen.
64. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula MX_3 ;
wherein M is a Group 13 metal; and
each X is a halogen.
65. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $\text{MR}_n\text{X}_{3-n}$;
wherein M is a Group 13 metal;
each R is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
 n is an integer from 1 to 3; and
each X is a halogen.
66. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $\text{M}(\text{RO})_n\text{R}'_m\text{X}_{3-(m+n)}$;
wherein M is a Group 13 metal;
each RO is a monovalent C_1 to C_{30} hydrocarboxy radical independently selected from the group consisting of an alkoxy, aryloxy, arylalkoxy, alkylaryloxy radicals;
each R' is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
 n is an integer from 0 to 3;
 m is an integer from 0 to 3, wherein the sum of n and m is from 1 to 3; and
each X is a halogen.

67. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $M(RC=OO)_nR'_mX_{3-(m+n)}$;
wherein M is a Group 13 metal;
each $RC=OO$ is a monovalent hydrocarbacyl radical independently selected from the group independently selected from the C_2 to C_{30} group consisting of an alkacyloxy, arylacyloxy, arylalkylacyloxy, alkylarylacyloxy radicals;
each R' is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
 n is an integer from 0 to 3;
 m is a integer from 0 to 3, wherein the sum of n and m is from 1 to 3; and
each X is a halogen.
68. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula MX_y ;
wherein M is a Group 15 metal;
each X is a halogen; and
 y is 3, 4 or 5.
69. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula MR_nX_{y-n} ;
wherein M is a Group 15 metal;
each R is a monovalent C_1 to C_{12} hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
 n is an integer from 0 to 4;
 y is 3, 4 or 5, wherein n is less than y ; and
each X is a halogen.
70. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $M(RO)_nR'_mX_{y-(m+n)}$;

wherein M is a Group 15 metal,
each RO is a monovalent C₁ to C₃₀ hydrocarboxy radical independently selected from the group consisting of an alkoxy, aryloxy, arylalkoxy, alkylaryloxy radicals;
each R' is a monovalent C₁ to C₁₂ hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
n is an integer from 0 to 4;
m is an integer from 0 to 4;
y is 3, 4 or 5, wherein the sum of *n* and *m* is less than *y*; and
each X is a halogen.

71. The copolymer of claim 35, wherein the one or more Lewis acid(s) is represented by the formula $M(RC=OO)_nR'_mX_{y-(m+n)}$;

wherein M is a Group 15 metal;
each RC=OO is a monovalent C₂ to C₃₀ hydrocarbacyloxy radical independently selected from the group consisting of an alkacyloxy, arylacyloxy, arylalkylacyloxy, alkylarylacyloxy radicals;
each R' is a monovalent C₁ to C₁₂ hydrocarbon radical independently selected from the group consisting of an alkyl, aryl, arylalkyl, alkylaryl and cycloalkyl radicals;
n is an integer from 0 to 4;
m is an integer from 0 to 4;
y is 3, 4 or 5, wherein the sum of *n* and *m* is less than *y*; and
each X is a halogen.

72. The copolymer of claim 35, wherein the one or more Lewis acid(s) is independently selected from the group consisting of titanium tetrachloride, titanium tetrabromide, vanadium tetrachloride, tin tetrachloride, zirconium tetrachloride, titanium bromide trichloride, titanium dibromide dichloride, vanadium bromide trichloride, tin chloride trifluoride, benzyltitanium trichloride, dibenzyltitanium dichloride, benzylzirconium trichloride,

dibenzylzirconium dibromide, methyltitanium trichloride, dimethyltitanium difluoride, dimethyltin dichloride, phenylvanadium trichloride, methoxytitanium trichloride, n-butoxytitanium trichloride, di(isopropoxy)titanium dichloride, phenoxytitanium tribromide, phenylmethoxyzirconium trifluoride, methyl methoxytitanium dichloride, methyl methoxytin dichloride, benzyl isopropoxyvanadium dichloride, acetoxytitanium trichloride, benzoylzirconium tribromide, benzoyloxytitanium trifluoride, isopropoyloxytin trichloride, methyl acetoxytitanium dichloride, benzyl benzoyloxyvanadium chloride, vanadium oxytrichloride, aluminum trichloride, boron trifluoride, gallium trichloride, indium trifluoride, ethylaluminum dichloride, methylaluminum dichloride, benzylaluminum dichloride, isobutylgallium dichloride, diethylaluminum chloride, dimethylaluminum chloride, ethylaluminum sesquichloride, methylaluminum sesquichloride, trimethylaluminum, triethylaluminum, methoxyaluminum dichloride, ethoxyaluminum dichloride, 2,6-di-tert-butylphenoxyaluminum dichloride, methoxy methylaluminum chloride, 2,6-di-tert-butylphenoxy methylaluminum chloride, isopropoxygallium dichloride, phenoxy methylindium fluoride, acetoxyaluminum dichloride, benzoyloxyaluminum dibromide, benzoyloxygallium difluoride, methyl acetoxyaluminum chloride, isopropoyloxyindium trichloride, antimony hexachloride, antimony hexafluoride, arsenic pentafluoride, antimony chloride pentafluoride, arsenic trifluoride, bismuth trichloride arsenic fluoride tetrachloride, tetraphenylantimony chloride, triphenylantimony dichloride, tetrachloromethoxyantimony, dimethoxytrichloroantimony, dichloromethoxyarsine, chlorodimethoxyarsine, difluoromethoxyarsine, acetatotetrachloroantimony, (benzoato) tetrachloroantimony, and bismuth acetate chloride.

73. The copolymer of claim 35, wherein the one or more Lewis acid(s) is independently selected from the group consisting of aluminum trichloride, aluminum tribromide, ethylaluminum dichloride, ethylaluminum

sesquichloride, diethylaluminum chloride, methylaluminum dichloride, methylaluminum sesquichloride, dimethylaluminum chloride, boron trifluoride, and titanium tetrachloride.

74. The copolymer of claim 35, wherein the Lewis acid is not a compound represented by formula MX_3 , where M is a group 13 metal, X is a halogen.
75. The copolymer of claim 35, wherein the one or more initiator(s) comprise a hydrogen halide, a carboxylic acid, a carboxylic acid halide, a sulfonic acid, an alcohol, a phenol, a polymeric halide, a tertiary alkyl halide, a tertiary aralkyl halide, a tertiary alkyl ester, a tertiary aralkyl ester, a tertiary alkyl ether, a tertiary aralkyl ether, an alkyl halide, an aryl halide, an alkylaryl halide or an arylalkylacid halide.
76. The copolymer of claim 35, wherein the one or more initiator(s) is independently selected from the group consisting of HCl, H_2O , methanol, $(CH_3)_3CCl$, $C_6H_5C(CH_3)_2Cl$, (2-Chloro-2,4,4-trimethylpentane) and 2-chloro-2-methylpropane.
77. The copolymer of claim 35, wherein the one or more initiator(s) is independently selected from the group consisting of hydrogen chloride, hydrogen bromide, hydrogen iodide, acetic acid, propanoic acid, butanoic acid; cinnamic acid, benzoic acid, 1-chloroacetic acid, dichloroacetic acid, trichloroacetic acid, trifluoroacetic acid, p-chlorobenzoic acid, p-fluorobenzoic acid, acetyl chloride, acetyl bromide, cinnamyl chloride, benzoyl chloride, benzoyl bromide, trichloroacetylchloride, trifluoroacetylchloride, p-fluorobenzoylchloride, methanesulfonic acid, trifluoromethanesulfonic acid, trichloromethanesulfonic acid, p-toluenesulfonic acid, methanesulfonyl chloride, methanesulfonyl bromide, trichloromethanesulfonyl chloride, trifluoromethanesulfonyl chloride, p-toluenesulfonyl chloride, methanol, ethanol, propanol, 2-propanol, 2-methylpropan-2-ol, cyclohexanol, benzyl alcohol, phenol, 2-methylphenol,

2,6-dimethylphenol, p-chlorophenol, p-fluorophenol, 2,3,4,5,6-pentafluorophenol, and 2-hydroxynaphthalene.

78. The copolymer of claim 35, wherein the one or more initiator(s) is independently selected from the group consisting of 2-chloro-2,4,4-trimethylpentane; 2-bromo-2,4,4-trimethylpentane; 2-chloro-2-methylpropane; 2-bromo-2-methylpropane; 2-chloro-2,4,4,6,6-pentamethylheptane; 2-bromo-2,4,4,6,6-pentamethylheptane; 1-chloro-1-methylethylbenzene; 1-chloroadamantane; 1-chloroethylbenzene; 1, 4-bis(1-chloro-1-methylethyl) benzene; 5-tert-butyl-1,3-bis(1-chloro-1-methylethyl) benzene; 2-acetoxy-2,4,4-trimethylpentane; 2-benzoyloxy-2,4,4-trimethylpentane; 2-acetoxy-2-methylpropane; 2-benzoyloxy-2-methylpropane; 2-acetoxy-2,4,4,6,6-pentamethylheptane; 2-benzoyl-2,4,4,6,6-pentamethylheptane; 1-acetoxy-1-methylethylbenzene; 1-acetoxyladamantane; 1-benzoyloxyethylbenzene; 1,4-bis(1-acetoxy-1-methylethyl) benzene; 5-tert-butyl-1,3-bis(1-acetoxy-1-methylethyl) benzene; 2-methoxy-2,4,4-trimethylpentane; 2-isopropoxy-2,4,4-trimethylpentane; 2-methoxy-2-methylpropane; 2-benzoyloxy-2-methylpropane; 2-methoxy-2,4,4,6,6-pentamethylheptane; 2-isopropoxy-2,4,4,6,6-pentamethylheptane; 1-methoxy-1-methylethylbenzene; 1-methoxyadamantane; 1-methoxyethylbenzene; 1,4-bis(1-methoxy-1-methylethyl) benzene; 5-tert-butyl-1,3-bis(1-methoxy-1-methylethyl) benzene, and 1,3,5-tris(1-chloro-1-methylethyl) benzene.
79. The copolymer of claim 35, wherein the one or more initiator(s) further comprise a weakly-coordinating anion.
80. The copolymer of claim 35, wherein the one or more initiator(s) comprise greater than 30 ppm water (based upon weight).
81. The copolymer of claim 35, wherein the contacting further comprises contacting one or more monomer(s) independently selected from the group

consisting of olefins, alpha-olefins, disubstituted olefins, isoolefins, conjugated dienes, non-conjugated dienes, styrenics, substituted styrenics, and vinyl ethers.

82. The copolymer of claim 35, wherein the contacting further comprises contacting one or more monomer(s) independently selected from the group consisting of styrene, para-alkylstyrene, para-methylstyrene, alpha-methyl styrene, divinylbenzene, diisopropenylbenzene, isobutylene, 2-methyl-1-butene, 3-methyl-1-butene, 2-methyl-2-pentene, isoprene, butadiene, 2,3-dimethyl-1,3-butadiene, β -pinene, myrcene, 6,6-dimethyl-fulvene, hexadiene, cyclopentadiene, methyl cyclopentadiene, piperylene, methyl vinyl ether, ethyl vinyl ether, and isobutyl vinyl ether.
83. The copolymer of any of the preceding claims, wherein the copolymer is halogenated to form a halogenated copolymer.
84. The copolymer of claim 83, wherein the halogenated copolymer is halogenated with chlorine or bromine.
85. The copolymer of claim 83 or 84, wherein the halogen content is greater than 0.5 wt% based upon the weight of the halogenated copolymer.
86. The copolymer of claim 83 or 84, wherein the halogen content is from 0.5 wt% to 3.0 wt% based upon the weight of the halogenated copolymer.
87. The copolymer of any of the preceding claims, wherein the copolymer has a Mw of from greater than 50,000.
88. The copolymer of any of the preceding claims, wherein the copolymer has a Mw of from greater than 100,000.

89. The copolymer of any of the preceding claims, wherein the copolymer has a Mw of from greater than 500,000.
90. The copolymer of any of the preceding claims, wherein the copolymer has a Mw of from greater than 1,000,000.
91. The copolymer of any of the preceding claims, wherein the copolymer has a MWD of from greater than 2.
92. The copolymer of any of the preceding claims, wherein the copolymer has a MWD of from 2 to 6.
93. The copolymer of any of the preceding claims, wherein the copolymer has a Mooney viscosity of at least 20 ± 5 (ML 1 + 8 at 125°C, ASTM D 1646).
94. The copolymer of any of the preceding claims, wherein the copolymer has a Mooney viscosity of from 20 ± 5 to 60 ± 5 (ML 1 + 8 at 125°C, ASTM D 1646).
95. A blend comprising the copolymer of any of the preceding claims and a secondary rubber independently selected from the group consisting of at least one of natural rubber, polyisoprene rubber, poly(styrene-*co*-butadiene) rubber (SBR), polybutadiene rubber (BR), poly(isoprene-*co*-butadiene) rubber (IBR), styrene-isoprene-butadiene rubber (SIBR), ethylene-propylene rubber (EPR), ethylene-propylene-diene rubber (EPDM), polysulfide, isobutylene/cyclopentadiene copolymer rubber, isobutylene/methyl cyclopentadiene copolymer rubber, nitrile rubber, propylene oxide polymers, star-branched butyl rubber and halogenated star-branched butyl rubber, brominated butyl rubber, chlorinated butyl rubber, star-branched polyisobutylene rubber, star-branched brominated butyl (polyisobutylene/isoprene copolymer) rubber; poly(isobutylene-*co-p*-methylstyrene) and halogenated poly(isobutylene-*co-p*-methylstyrene),

halogenated poly(isobutylene-co-isoprene-co-p-methylstyrene),
poly(isobutylene-co-isoprene-co-styrene), halogenated poly(isobutylene-
co-isoprene-co-styrene), poly(isobutylene-co-isoprene-co- α -
methylstyrene) halogenated poly(isobutylene-co-isoprene-co- α -
methylstyrene), and mixtures thereof.